

Work Order ID 61212

Wednesday, August 11, 2010 10:18:29 AM

Page 1

Item ID: D3278-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Support Assembly

Start Date: 8/11/2010 Start Qty: 40.00

Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 40.00

Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 10-8-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3278

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Rivet spacers with support as per Dwg D3278.

8/30/08/17 (40)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*Solo 8/17**counted (40)*

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble support as per Dwg D3278. □***DO NOT TIGHTEN
BOLTS*** □Identify as D3278-041*8/30/08/17 (40)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3278-041

Accept



Setup Start



Revision ID:

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Item Name: Support Assembly

Start Date: 8/11/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 40.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				10000 (X40)			
140 Packaging Packaging	Identify as per dwg & Stock Location: <u>51 471</u> Memo	0.00 0.00				(X40) BB			10/08/18
150 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/08/18 mf 10-8-18

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Picklist Print

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Work Order ID: 61212

Parent Item: D3278-041

Parent Item Name: Support Assembly

Start Date: 8/11/2010


Required Date: 8/25/2010

Start Qty: 40.00


Required Qty: 40.00

Comments: IPP: ☐A☐04.04.19☐New issue☐KJ/JLM
IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-13A  Bolt		Purchased	No			120	Each	888.0000	2	80		8/10/08/17	
---	--	-----------	----	--	--	-----	------	----------	---	----	--	------------	--


Location	Loc Qty	Loc Code
ST357	388	
115108	388	
ST358	500	
115159	500	

* AN960JD416  Washer	NAS1149D0463J	Purchased	No			120	Each	0.0000	4	160		8/10/08/17	
--	---------------	-----------	----	--	--	-----	------	--------	---	-----	--	------------	--

160x

D2230-1  Lug		Manufactured	No			120	Each	139.0000	2	80		8/10/08/17	
---	--	--------------	----	--	--	-----	------	----------	---	----	--	------------	--

Location	Loc Qty	Loc Code
ST476	139	
60289	139	

D3278-1  Support		Manufactured	No			100	Each	51.0000	1	40		8/10/08/17	
--	--	--------------	----	--	--	-----	------	---------	---	----	--	------------	--

Location	Loc Qty	Loc Code
ST045	44	
59917	20	
60564	24	
ST048	7	
51353	7	

20
20

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Parent Item: D3278-041

Parent Item Name: Support Assembly

Start Date: 8/11/2010

Required Date: 8/25/2010

Start Qty: 40.00

Required Qty: 40.00

D3278-2
Support
Manufactured No

100 Each 49.0000 1

40

Location Loc Qty Loc Code

ST048 49
59918 25
60565 24

25
15

D3278-3
Spacer
Manufactured No

100 Each 144.0000 1

40

Location Loc Qty Loc Code

ST045 87
60244 87
ST049 57
60081 57

40

MS20426AD3-6
Rivet
Purchased No

120 Each 1,626.000 4

160

Location Loc Qty Loc Code

ST316 1626
105055 1626

160

MS21042L4
Nut
Purchased No

100 Each 3,257.000 2

80

Location Loc Qty Loc Code

ST300 3257
113422 68
114523 28
114718 16
114784 1145
115108 2000

80

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Shop Packet Print

Page 2

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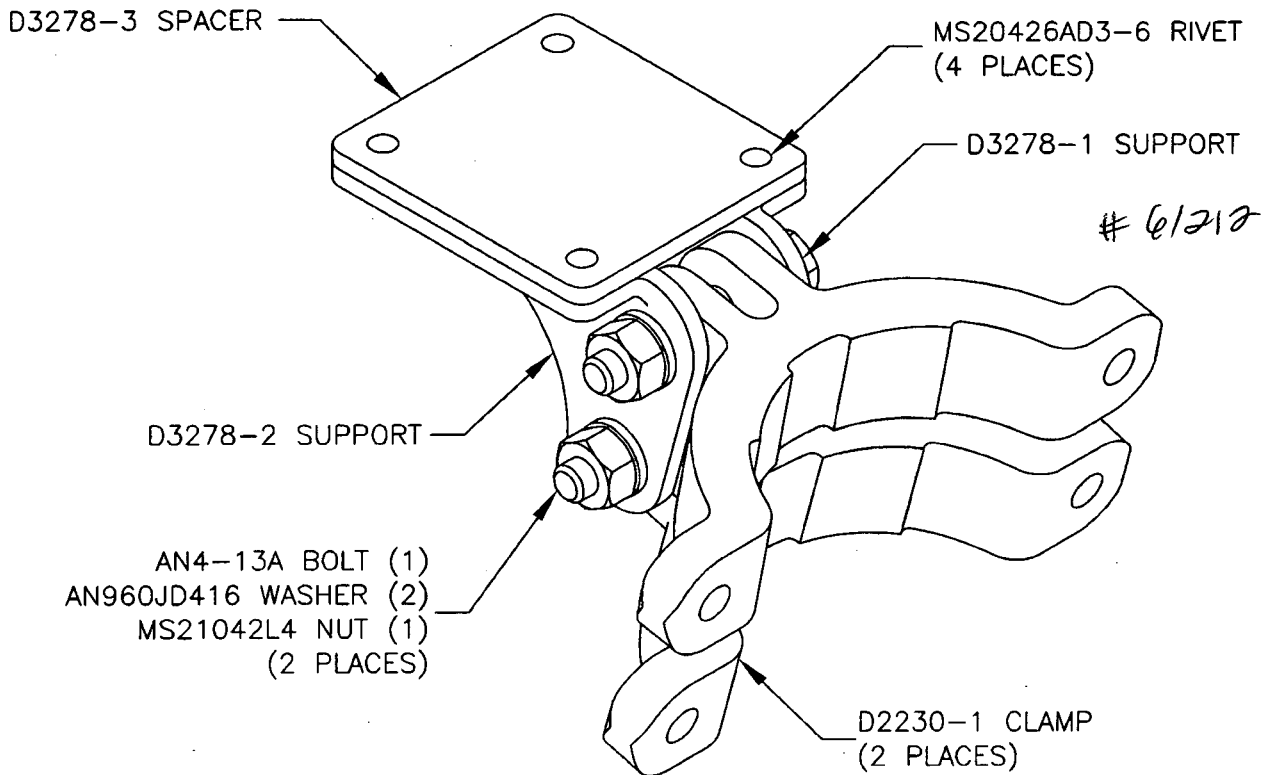
NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-06

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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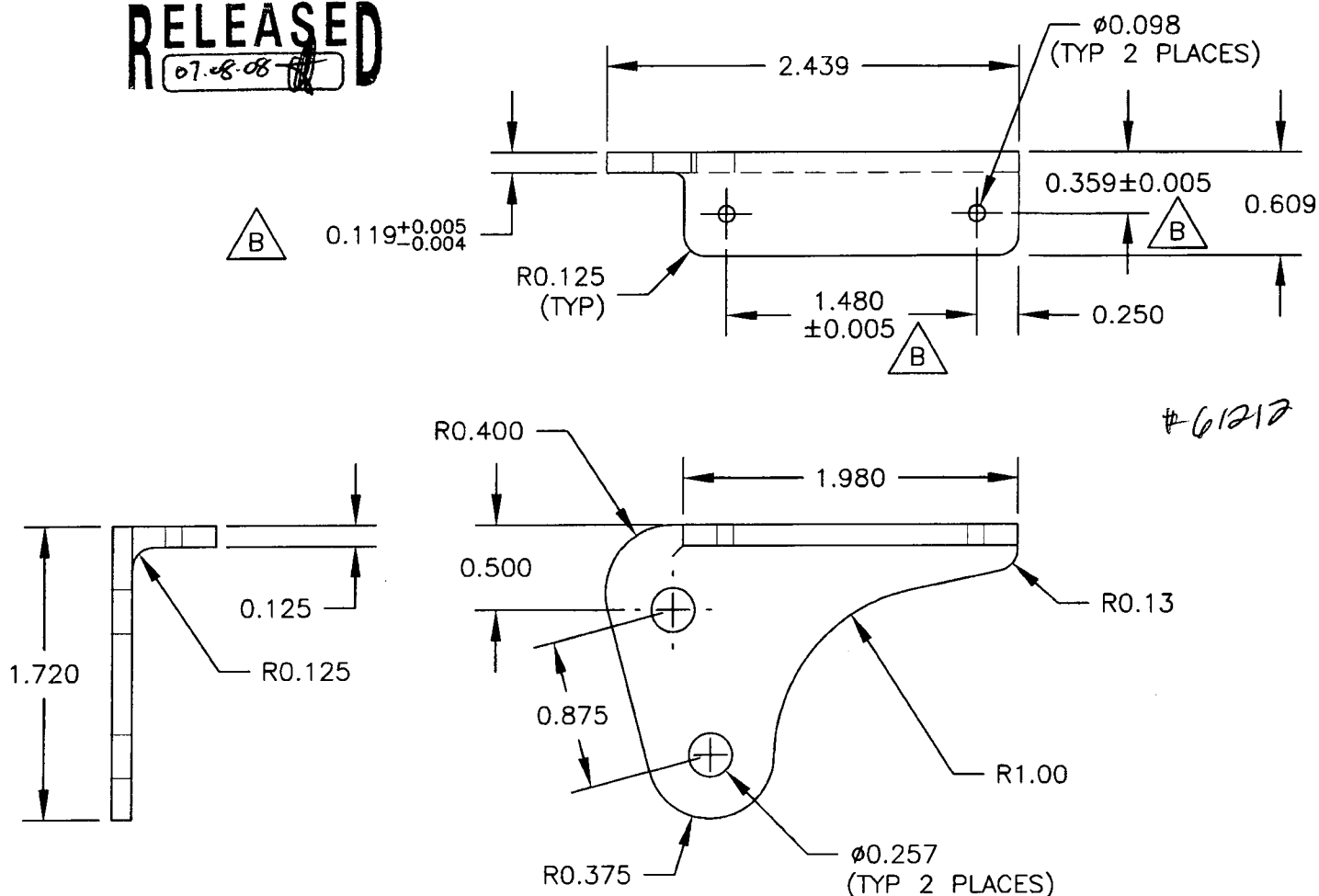
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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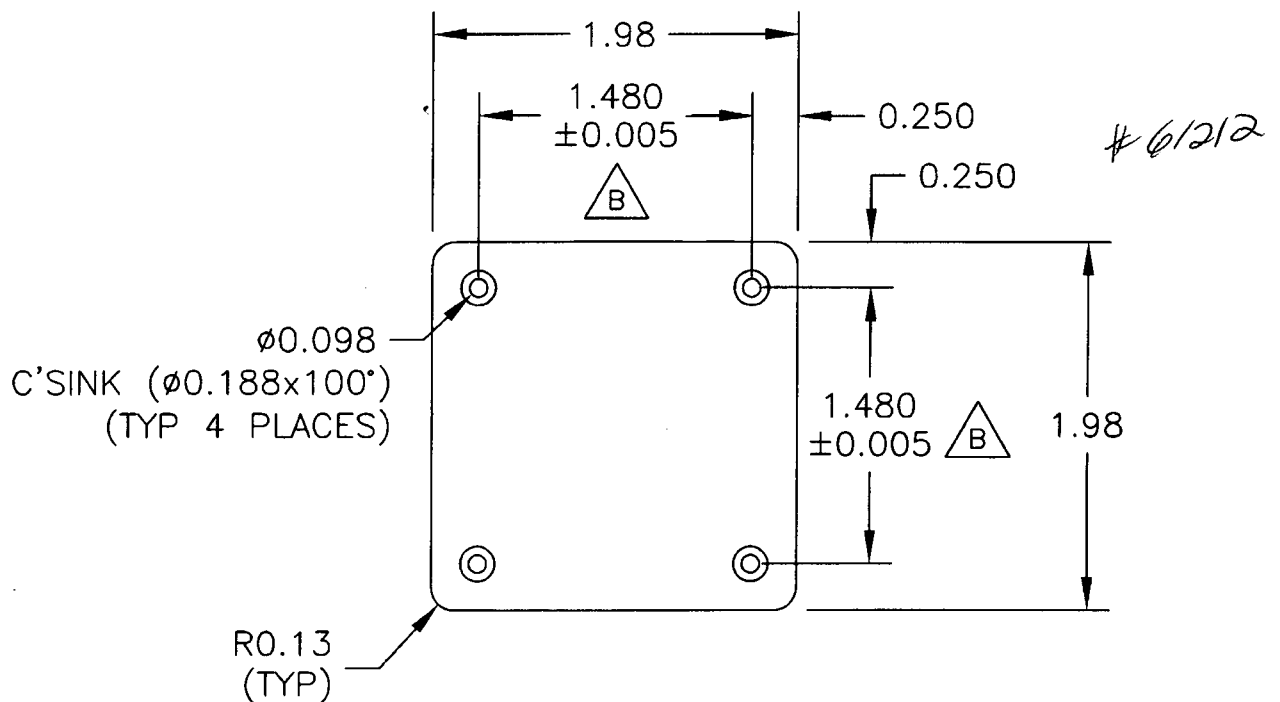
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CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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